



# **RUST BUSTER**

FRAME REPAIR

**RB4022**

**Jeep® TJ Wrangler  
Rear Cross Member**



### **REQUIRED TOOLS**

Jack Stands or Lift  
Mig Welder  
Paint/Primer  
Locking Pliers  
Hand Grinder  
Cutting Wheel or Torch  
Welding Gloves  
Welding Hood/Shield  
Ear & Eye Protection  
Sockets & Ratchet  
Fire Extinguisher & Water

### **KIT CONTAINS**

Rear Cross Member

### **QTY**

1



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**1) PREPARING YOUR VEHICLE**

Begin by disconnecting your battery prior to starting your installation.

Inspect your vehicle for leaking fuel lines, fuel tank and engine components. If you have fuel leaks repair all leaks prior to starting your installation. If your fuel tank is near your welding area **remove your tank prior to welding.**

Remove all combustible items above the work area such as seats, carpets, padding, etc.

**Keep all flammable materials away from the vehicle work area.**

**2) PREPARING YOUR WORKSTATION**

Keep a fire extinguisher and water close by in the case of fire and make sure you always have a designated "Fire Watch" to assist during the cutting or welding phases.

Abide by all apprenticed welding safety standards and practices.

Always use appropriate welding eye protection, ear protection, and work and fire safety gloves during the installation and within the work area.



**WARNING!**

If you are unsure on how to perform the installation or how to operate any of the required tools listed above, it is **HIGHLY** advised that you enlist the work of a certified welder/installer.

Failure to follow proper safety precautions and instructions may result in serious injury. **The user assumes all liability when installing the product.**



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### 3) PREPARING FOR YOUR INSTALL

Lift your vehicle.

Support your rear axle using two jack stands for the driver and passenger sides.

Drop and remove the gas tank and all cords and tubes associated with it, and plug/cover the remaining tubes to prevent fume leakage. Place it safely outside of your workstation as it poses as a fire hazard during installation.

Remove rear bumper.



Using a 16mm socket, remove the two body mount bolts and remove the bushings.



Depending on how you intend to cut, clean the cut zones free of rust and down to bare metal.

### 4) CUT

Cut and remove the Rear Cross Member as close to the frame rails as possible.



Depending on your level of experience, you may want to cut just outside of the frame rail to avoid cutting the frame. This will require you to remove any excess metal, such as welds, from the frame rails.





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Cut and remove the center Rear Cross Member segment.



Finally, remove the remaining metal from the ends of the frame rails, ensuring that it is obstruction free.

### 5) TEST FIT PART

Attempt to push the part into place and over the remaining frame. The part may require force to fit flush with the frame.

Take note of any difficulties and cut away any obstructions.



Ensure the two body mount bushing holes in the part line up with the body mount holes in the vehicle's body.



We recommend the Rear Cross Member be level. Note: Any frame deformations may result in the part sitting at an angle.



### 6) WELDING PREP

Once the part has been fitted, prepare your weld zones by clearing away any rust or debris, revealing bare metal.





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Replace the part and tack weld or clamp it into place to prevent it from moving later.

### 7) WELD

Remove any remaining potential fire hazards on both the vehicle and surrounding area. Following proper welding procedures begin welding the part onto the frame rails.



100% weld around all edges.



### 8) PAINT AND PROTECT

Coat the Rear Cross Member with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

### 9) REASSEMBLE VEHICLE

Begin reassembling your vehicle by reinstalling the body bolts and body mount bushings with a 16mm socket.



Reinstall your rear bumper.

Reinstall your gas tank, cords, and tubes.

Reconnect your battery.